

# Work Order ID 60074

June 24, 2010 9:04:30 AM



Page 1

Item ID: D3245-041

Accept



Setup Start



Revision ID:

Item Name: Access Panel Assembly

Stop



Start Date: 6/24/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: 

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3245

Rev B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*ES 10/07/29 (4)*

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Rivets and Nut Plates and D3245-5 angle as per Dwg D3245. Be careful when countersinking...mat'l very thin

*ES 10/08/03 (4)*

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*S10108103*

*(74)*

*2041*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 60074**

June 24, 2010 9:04:31 AM

Page 2

Item ID: D3245-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Access Panel Assembly

Start Date: 6/24/10 Start Qty: 4.00

Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location: 233B

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/8/4 sl (42)

10/08/04 HJ

N 10-8-09  
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 24, 2010 9:04:29 AM

Page 1

Work Order ID: 60074

Parent Item: D3245-041

Parent Item Name: Access Panel Assembly

Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue 07-09-11 JLM Verified By:EC  
IPP Rev:b ECN 1052 07-10-31 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

2350-18-C3Y

Purchased

No

110

Each

196.0000

8

32



RIGID RECEPTACLE

Location

Loc Qty

Loc Code

ST399

196

111129

26

111581

75

19688

95

D3245-1

Manufactured

No

110

Each

7.0000

1

4



Panel

Location

Loc Qty

Loc Code

ST233A

7

47609

7

D3245-5

Manufactured

No

110

Each

27.0000

1

4



Door

Location

Loc Qty

Loc Code

ST233B

27

47591

15

47610

12



ES 10/08/03

26

ES 10/08/03

4

ES 10/08/03

4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 24, 2010 9:04:30 AM

Page 2

Work Order ID: 60074

Parent Item: D3245-041

Parent Item Name: Access Panel Assembly



Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 4.00

Required Qty: 4.00

MS20427M3-3

Purchased

No

110

Each

532.0000

16

64



Rivet



*E/S 10/08/03*

Location

Loc Qty

Loc Code

ST318

532

112933

8

113064

524

64

MS20615M3-3

Purchased

No

110

Each

123.0000

9

36



Rivet



*E/S 10/08/03*

Location

Loc Qty

Loc Code

ST323

123

108558

23

111650

100

23

13

June 24, 2010 9:04:30 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

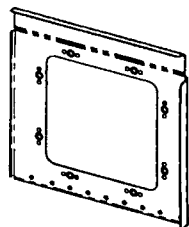
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





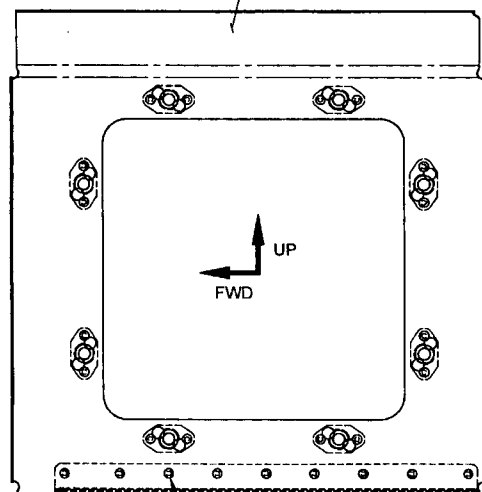
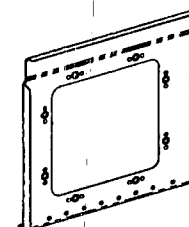
D3245-1  
PANEL

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)

*no  
60074*

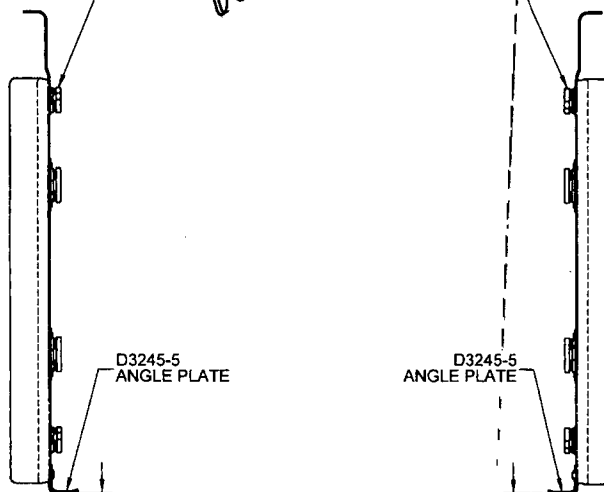
2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)

D3245-2  
PANEL



MS20615M3-3 RIVET  
(9 PLACES)

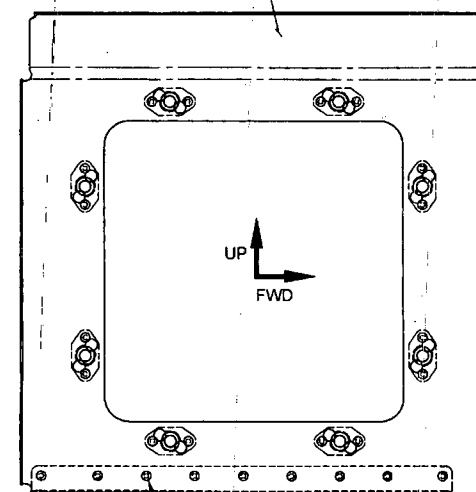
**D3245-041 ACCESS PANEL ASSEMBLY**



0.032  
GAP

D3245-5  
ANGLE PLATE

0.032  
GAP



MS20615M3-3 RIVET  
(9 PLACES)

**D3245-042 ACCESS PANEL ASSEMBLY**

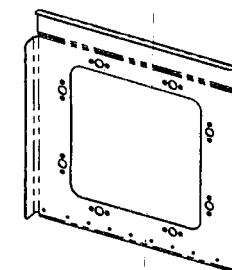
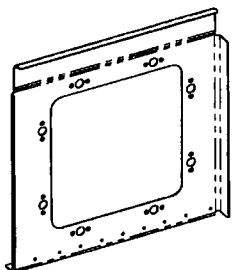
**RELEASED**  
*107-10-23*

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
	1	D3245-2	PANEL
1		D3245-5	ANGLE PLATE
8		2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

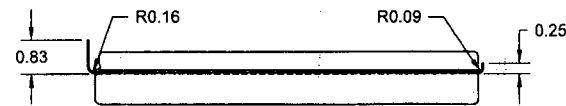
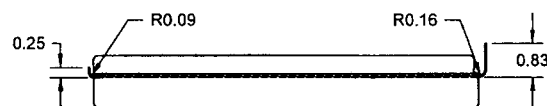
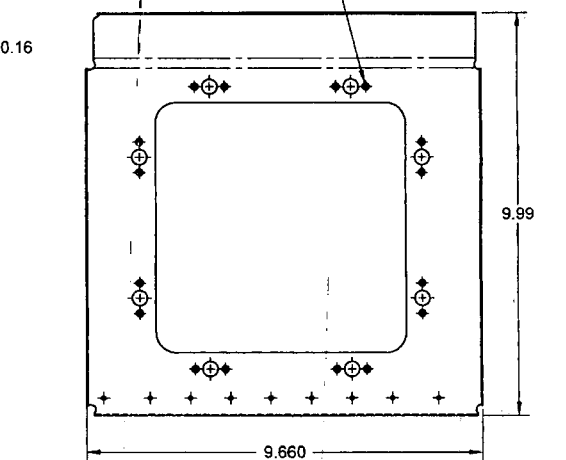
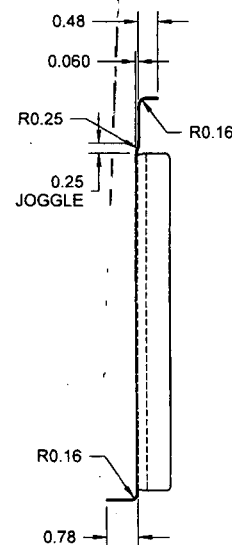
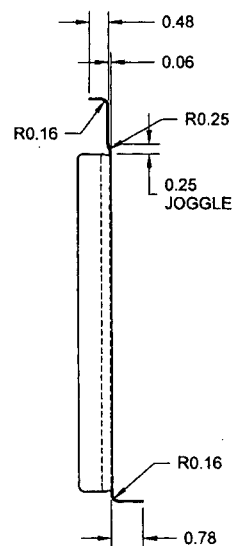
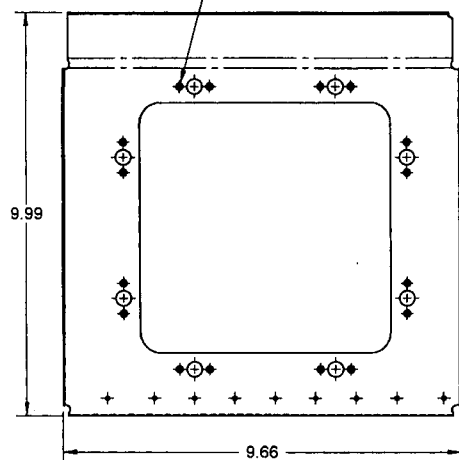
B: REMOVE 0.0204 HOLES FROM D3245-1/-1F. REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING		MB	07.10.02
A: NEW ISSUE		RF	04.01.27
REV.	DESCRIPTION		BY DATE
DESIGN	DART AEROSPACE LTD		
DRAWN	HAWKESBURY, ONTARIO, CANADA		
CHECKED	DRAWING NO. D3245		REV. B
MFG. APPR.	SHEET 1 OF 7		
APPROVED	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:2.5
DE APPR.	COPYRIGHT © 2004 BY DART AEROSPACE LTD		
DATE 07.10.02	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		



60074

C'SINK  $\phi 0.170 \times 100^\circ$   
(16 PLACES)

C'SINK  $\phi 0.170 \times 100^\circ$   
(16 PLACES)



**D3245-1 PANEL BEND DETAIL, LH**

**D3245-2 PANEL BEND DETAIL, RH**

**RELEASED**  
10-10-23

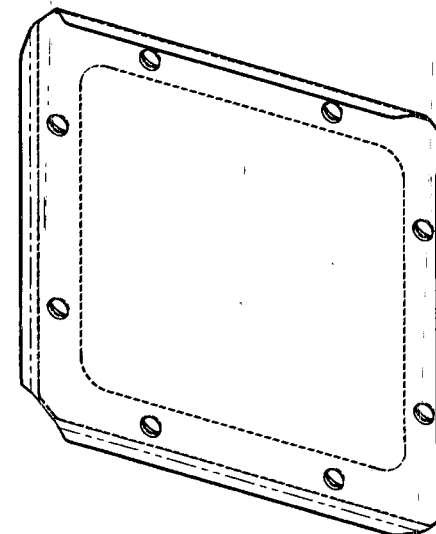
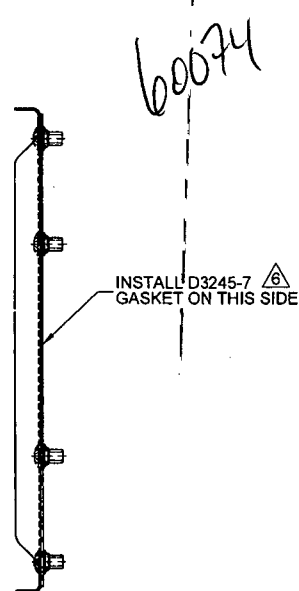
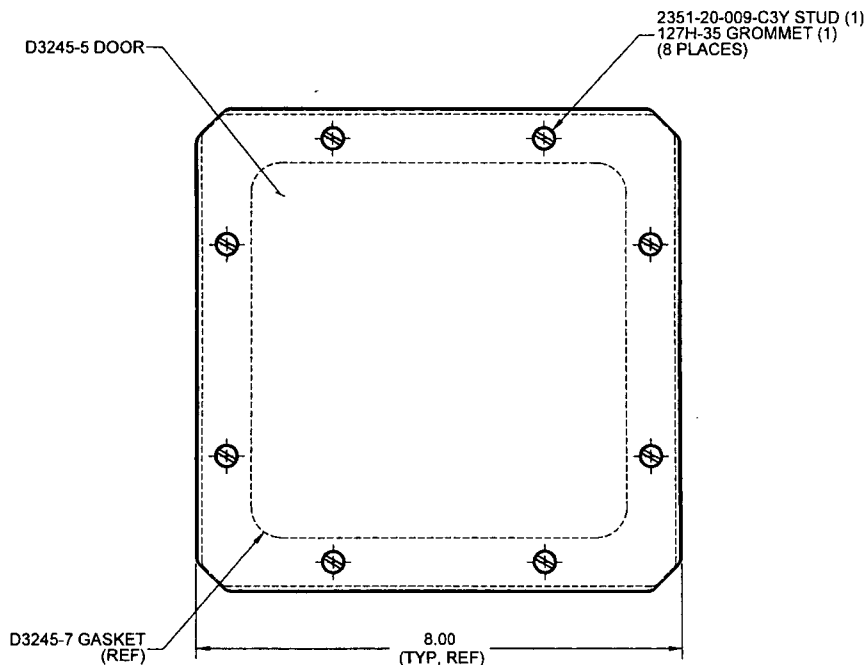
**NOTES:**

- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. <b>D3245</b>	REV. B
MFG. APPR.	PH	SHEET 2 OF 7	
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	<b>ACCESS PANEL ASSEMBLY</b>	
DATE	07.10.02	1:3	

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8 7 6 5 4 3 2 1



**D3245-043 DOOR ASSEMBLY**

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

**NOTES:**

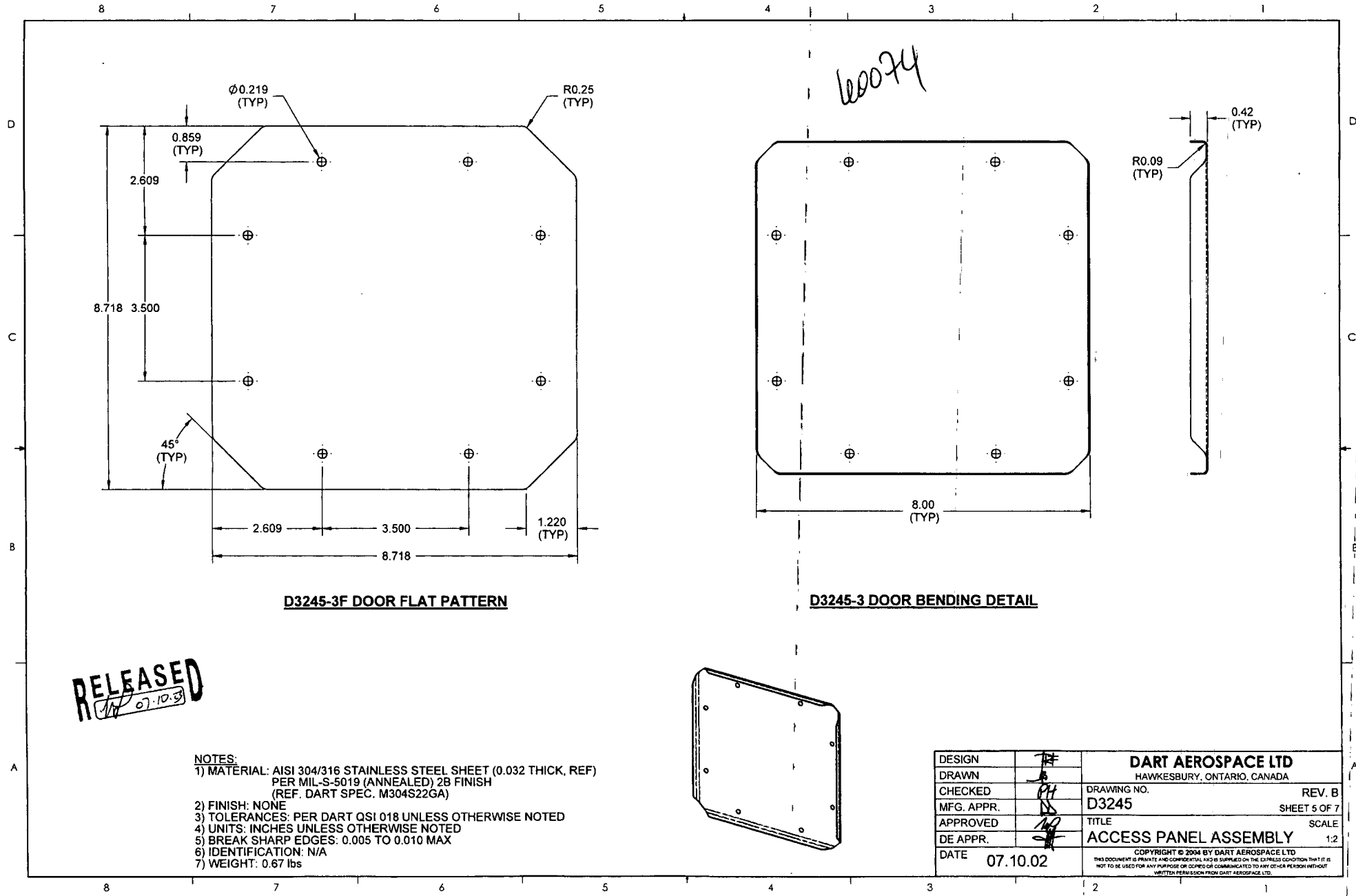
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

**RELEASED**  
WP 27-10-23

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D3245</b>	SHEET 3 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>ACCESS PANEL ASSEMBLY</b>	1:2
DATE	<b>07.10.02</b>	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1



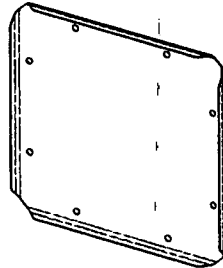


D3245-3F DOOR FLAT PATTERN

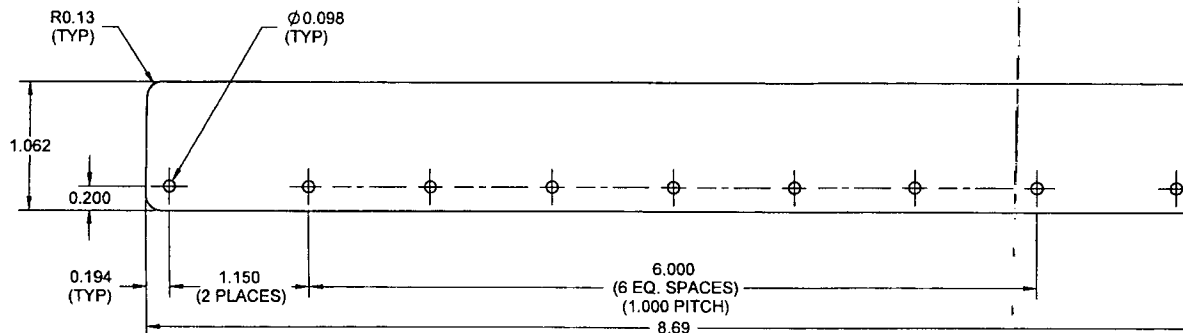
D3245-3 DOOR BENDING DETAIL

RELEASED  
07.10.02

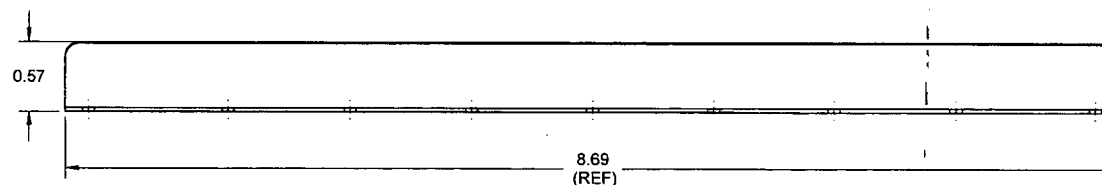
- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.67 lbs



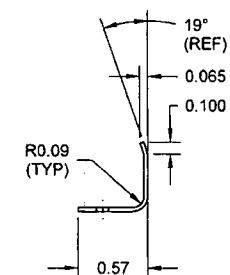
DESIGN	JH	DART AEROSPACE LTD	
DRAWN	JH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JH	DRAWING NO.	REV. B
MFG. APPR.	JH	D3245	SHEET 5 OF 7
APPROVED	JH	TITLE	SCALE
DE APPR.	JH	ACCESS PANEL ASSEMBLY	1:2
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**D3245-5F FLAT PATTERN**



**D3245-5 BEND DETAIL  
(MAKE FROM D3245-5F)**

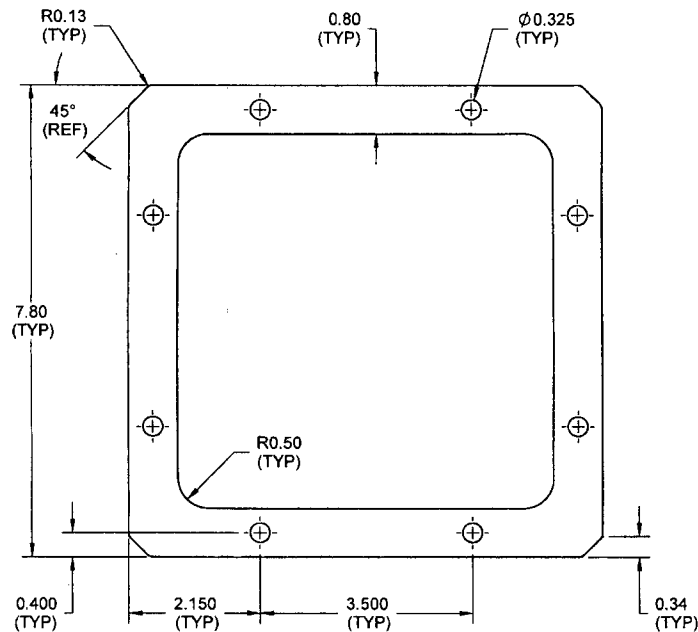


**RELEASED**  
07.10.23

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D3245</b>	SHEET 6 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>ACCESS PANEL ASSEMBLY</b>	1:1
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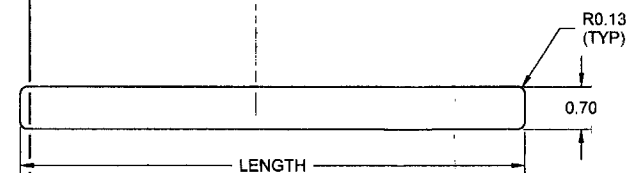


**D3245-7 GASKET**

**RELEASED**  
07.10.02

**NOTES:**

- 1) MATERIAL: DURABLA BLACK GASKET, 0.035 THICK  
(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A



**D3245-X GASKET**

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

*60074*

DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. 8
MFG. APPR.	<i>PH</i>	<b>D3245</b>	SHEET 7 OF 7
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	<b>ACCESS PANEL ASSEMBLY</b>	1:2
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